

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016477**Date Inspected:** 28-Aug-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu tao / Wang jie /Wu shi gao			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG Components		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld joint 2F-032 located on PCMK SB019-078 of SB78E the welder is identified as 062808. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 2F-026 located on PCMK SB016-072 of SB72W the welder is identified as 062783. ZPMC QC is identified as Mr. Li ming yang. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

BAY#14

SAW welding of weld joint 1G-001 located on PCMK SEG3015A of Segment 13CW the welder is identified as 0455270. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 1G-006 located on PCMK SEG3007AD of Segment 13AE the welder is identified as 044790. ZPMC QC is identified as Mr. Wang jie. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2233-B-U2-F.

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FCAW welding of weld joint 2F-071 located on PCMK CA3015 of Segment 13BW the welder is identified as 047866. ZPMC QC is identified as Mr. Xia chun hui The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

FCAW welding of weld joint 3G-197 located on PCMK SSD25-PP110 of Segment 12AW the welder is identified as 202122. ZPMC QC is identified as Mr. wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

ZPMC personnel have started to install the Bottom plates for lift 13 East and West line.

This QA inspector performed UT 10% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an UT report for this date. The members are identified as OBG Segment 13BE. The weld designations reviewed as follows.
SEG3009A-003,004.

OUTSIDE SHOP

SMAW welding of weld repair joint 3G-003 located on PCMK SEG3001R of Segment 12AE the welder is identified as 044772. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-3G(3F)-Repair.

SMAW welding of weld joint 2G-226 located on PCMK SEG3001J of Segment 12AE the welder is identified as 050232. ZPMC QC is identified as Mr. Li ping. The welding variables recorded by QC appeared to Comply with the WPS-B-P2212-Tc-U4b-FCM-1.

In Segment 11EE ZPMC QC NDT personnel performing their MT on Deck panel U-ribs and Floor beam flange welds at PP 107,108.

BLAST SHOP#1

Caltrans Quality Assurance (QA) Inspectors performed random visual inspection of OBG segment 11AW Exterior bottom panel, side panel and deck panel surfaces from the panel point 95 to 97 after grit blasting. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
